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013516



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2873-045**Job Sheet 202848**

Part No: D2873-045

Job Qty: 4 pcs

30

Part Name: Nut Plate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/4/19

Job Tracking No:

Due Date: 11/25/19

Dec 5

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP A 05.09.13 New issue KJ/JLM

Ship Via:

Bill of Materials**Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	4 pcs		11/25/19	0.00	0.04	Bandsaw - 1		
110	HAAS 4 Axis - B4B	4 pcs		11/25/19	0.09	1.02	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	4 pcs		11/25/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		

DAS 52 19/11/30
9-89 19/12/13

DAS 52 19/12/13
9-89



Container No: S236321



Part: D2873-045

Job No: 202848

Serial No/Batch: S236321

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/30/19

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1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
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130 QC 8	4 pcs	11/25/19	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	19/2/13
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
140 Small Fab - 2 - B4B	4 pcs	11/25/19	0.00 0.11	QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
150 QC 5	4 pcs	11/25/19	0.00 0.00	Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	

160 Handfinish - 1-1 Chemical-B4B	4 pcs	11/25/19	0.00 0.08	QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
170 QC 7	4 pcs	11/25/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	

DEC 16 2019

					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	DEC 17 2019
					QC 7 - 76	
					QC 7 - 79	
180 Small Fab - 3 - B4B	4 pcs	11/25/19	0.00 0.11		Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	DEC 17 2019
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
190 QC 5	4 pcs	11/25/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	JAN 02 2020
					QC 5 - 61	
					QC 5 - 81	
200 Packaging 3-1 - Stock - B4B	4 pcs	11/25/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	L9050 DAS 74 JAN 03 2020
					Packaging 3 - 5 - B4B	9-89
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	

DAS
82
9-89DAS
81
9-89DAS
40
9-89DAS
82
9-89

				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	4 pcs	11/25/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	JAN 03 2020 70
				QC 21 - SA - 53	9-89
Part Op 100 - (Bandsaw) Cut blanks: 1.000" x 0.375" x 2.700" long Descriptions: 110 - HAAS1-2 (HAAS CNC Vertical Machine) Machine as per Folio FA and Dwg D2873 Identify as D2873-5 Dwg Rev <u>A</u> F1819Folio Rev <u>A</u> 120 - (QC2- Inspect parts off machine FA/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Small Fab) 1-Deburr 150 - (QC5- Inspect part completeness to step on W/O) 160 - (Chemical Conversion Coat per QSI005 4.1) 170 - (QC7-Inspect Chemical Conversion Coat) 180 - (Small Fab) 1-Assemble as per Dwg D2873 2-Identify as D2873-045 190 - (QC5- Inspect part completeness to step on W/O) 200 - (Identify as per dwg & Stock Location: _____) (Identify as per dwg & Stock Location: _____) LOCATION : LG050 210 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6B0.375X1.000	6061T6 Bar .375 X 1.00	.9000 ft (.225 ea)	100-Bandsaw - 1	5188590-704	
MS20426AD4-6	Rivet	16 Ea (4 ea) 120	180-Small Fab - 3 - B4B	5235269	
MS21075L5	Nut Plate	8 Ea (2 ea) 60	180-Small Fab - 3 - B4B	3233769	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Bandsaw - 1	M6061T6B0.375X1.000	1	20	0	
180-Small Fab - 3 - B4B	MS20426AD4-6	16	845	0	
	MS21075L5	8	18	0	
Part Specifications					
Specifications could not be found.					

Plex 11/4/19 3:24 PM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 202848
Description: Radius Block		Part Number: D2873-5
Inspection Dwg: D2873	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.495	✓		Ver	
1.000	+/-0.010	1.000	✓		Ver	
0.750	+/-0.010	0.748	✓		Ver	
0.250	+/-0.010	0.248	✓		Ver	
1.000	+/-0.010	0.999	✓		Ver	
2.000	+/-0.010	2.000	✓		Ver	
Ø0.128	+0.005/-0.001	0.128	✓		G.P.	
0.359	+/-0.010	0.359	✓		Ver	
Ø0.316	+0.006/-0.001	0.316	✓		G.P.	
1.000	+/-0.010	1.000	✓		Ver	
0.250	+/-0.010	0.250	✓		Ver	
0.061	+/-0.010	0.061	✓		Ver	
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	0.230 x 0.125	✓		Ver	

Measured by: DAS 52 9-89	Audited by:	Prototype Approval:	N/A
Date: 19/12/13	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-045	KJ/JLM	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)
Description Work Order Deviation		Disposition		Completed By
				Lead hand / Supervisor
				QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
Other/Details:				